

Work Order ID 139692

139692

Tuesday, December 01, 2015 9:55:42 AM

Page 1

Item ID: D4030-041 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Long Basket Assembly (350)

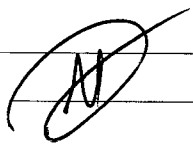
Start Date: 11/30/2015 Start Qty: 1.00 *1*

Required Date: 11/30/2015 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date: 12-01 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4030	D

100	Pick Kit	0.00
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100

Packaging Memo 0.00

Packaging

JAN 06 2016

DAS
6
9-89

110	Assemble as per dwg	0.00
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110

HandFinish Memo 0.02

Hand Finishing

1x of 16/01/07

120	QC5- Inspect part completeness to step on W/O	0.00
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120

QC Memo 0.00

Quality Control

JAN 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 139692***139692***

Page 2

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Item ID: D4030-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Assembly (350)
Start Date: 11/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/30/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00				1		DAS 28 9-89	JAN 08 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS JAN 11 2016

mf
16-1-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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				OTHER :							

Picklist Print

Tuesday, December 01, 2015 9:55:41 AM

Page 1

Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	6.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				ST379				6					
				137880				6					
D2535 *D2535* Spring		Manufactured	No			100	Each	70.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				ST008				45					
				137337				45					
				ST012a				25					
				138588				25					
D2537 *D2537* Bushing		Manufactured	No			100	Each	55.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				ST008				35					
				135535				35					
				ST012a				20					
				137921				20					
D3913-041 *D3913-041* Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				ST008				35					
				135535				35					
				ST012a				20					
				137921				20					

JAN 06 2016

B139691 (1x) 11/16/07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

**

139692 Cxll 15/10/15

D3917-3 Manufactured No

100 Each 110.0000 6 6

D3917-3

Washer

**

Location

Loc Qty

Loc Code

DAS

ST058

34

6
9-89

121801

1

136542

14

138298

19

ST064A

76

137917

51

138960

25

6

D3953-3 Manufactured No

100 Each 40.0000 2 2

D3953-3

Gas Spring Stud, Lid

**

DAS

Location

Loc Qty

Loc Code

6
9-89

ST0062

40

136645

40

2

D3953-7 Manufactured No

100 Each 96.0000 2 2

D3953-7

Spring Spacer

**

JAN 06 2016

Location

Loc Qty

Loc Code

DAS
6
9-89

ST062

16

135499

6

137212

10

ST064A

80

137919

20

138972

60

2

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each 62.0000 2 2

D3953-9

Gas Spring Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

39

135544

39

ST064A

23

139013

23

2

D3953-17 Manufactured No

100 Each 47.0000 2 2

D3953-17

Gas Spring Spacer

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

47

136481

47

D3953-19 Manufactured No

100 Each 14.0000 1 1

D3953-19

Gas Spring Bracket

DAS
6
9-89

Location

Loc Qty

Loc Code

ST062

9

131776

1

136464

8

ST064A

5

137903

5

D3953-21 Manufactured No

100 Each 25.0000 1 1

D3953-21

Gas Spring Bracket

DAS
6
9-89

Location

Loc Qty

Loc Code

ST063

25

132602

25

JAN 06 2016

Tuesday, December 01, 2015 9:55:41 AM

Shop Packet Print

Page 3

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WORK ORDER NON-CONFORMANCE / UPDATE

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Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																		
Folio/Program	☐	Outside Dimensions	☐																																																																																																																																		
Grain	☐	Over/Under tolerance	☐																																																																																																																																		
Weld	☐	Part Incorrect	☐																																																																																																																																		
Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																		
Out of Sequence	☐	Part Moved	☐																																																																																																																																		
Off-set	☐	Drawing	☐																																																																																																																																		
Mislabeled	☐	Finish	☐																																																																																																																																		
Fit/Function	☐	Misread	☐																																																																																																																																		
Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																		
		OTHER : _____																																																																																																																																			

Picklist Print

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

D3969-3	Manufactured	No	100	Each	22.0000	1	1	DAS 6 9-89
D3969-3								
Prop								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST365	22	
135397	4	
136918	8	
137894	10	

AN3-14A	Purchased	No	100	Each	117.0000	4	4	DAS 6 9-89
AN3-14A								
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338a	100	
m133363	100	
ST348	17	
m132825	17	

AN3-16A	Purchased	No	100	Each	59.0000	2	2	DAS 6 9-89
AN3-16A								
Bolt								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	45	
117441	45	
ST348	14	
M133011	14	

JAN 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Picklist Print

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

114.0000

4

4

AN5-17A

Bolt

Location

Loc Qty

Loc Code

DAS

GA

36

6

117872

36

9-89

ST299A

50

m133077

50

ST337

28

m133577

28

AN4-12

Purchased

No

100

Each

83.0000

3

3

AN4-12

Bolt

Location

Loc Qty

Loc Code

ST325A

28

m128813

3

m133363

25

ST344

55

m132317

5

m133578

50

AN310-4

Purchased

No

100

Each

90.0000

3

3

AN310-4

Nut

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

65

M132382

15

M133483

50

DAS
6
9-89

JAN 06 2016

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

85.0000

2

2

AN310C4

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

ST331

85

M131305

2

M132344

6

M133234

17

M133483

40

M133694

20

2

MS21042L3

Purchased

No

100

Each

328.0000

6

6

MS21042L3

Nut

DAS

6

9-89

133790

Location

Loc Qty

Loc Code

FP001

95

M130922

95

GA

84

M131317

84

ST304

149

M130922

149

DAS

6

9-89

JAN 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

514.0000

4

4

MS21042L5

Nut

Location

Loc Qty

Loc Code

CCK004

200

m133577

200

GA

146

m127813

146

ST304

120

m133363

120

ST305

48

m127813

19

m131340

21

m132123

8

DAS
6
9-89

MS24665-151

Purchased

No

100

Each

86.0000

3

3

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

59

m128401

59

ST289

27

m128401

6

m129909

21

DAS
6
9-89

133169

MS24665-300

Purchased

No

100

Each

101.0000

2

2

MS24665-300

COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST288

71

M128812

71

DAS
6
9-89

JAN 06 2016

2

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER : _____																																																																																																																															

Picklist Print

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

942.0000

6

6

NAS1149F0432P

WASHER

Location

Loc Qty

Loc Code

ST262

760

M132551

260

M133709

500

st268

182

M128995

57

M132677

125

DAS

6

9-89

NAS1149F0563P

Purchased

No

100

Each

241.0000

4

4

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST260a

200

m133515

200

ST267

13

121350

13

st268

28

m132344

28

DAS

6

9-89

NAS1149F0332P

Purchased

No

100

Each

1,918.000

8

8

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

ST262

1918

m133709

1918

JAN 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Work Order ID: 139692

139692

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

1,035.000

2

2

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

450

m125807

428

m131467

22

ST266

585

m131467

85

m133577

500

DAS

6

9.89

JAN 06 2016

DQA: _____ Date: _____



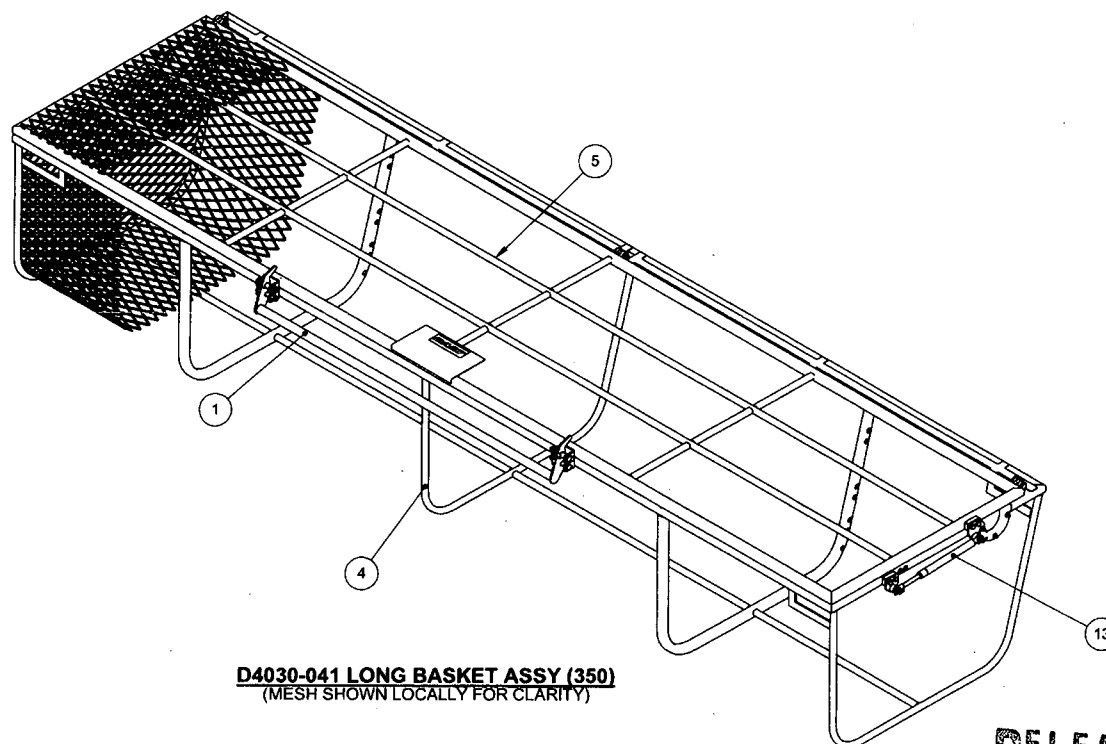
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

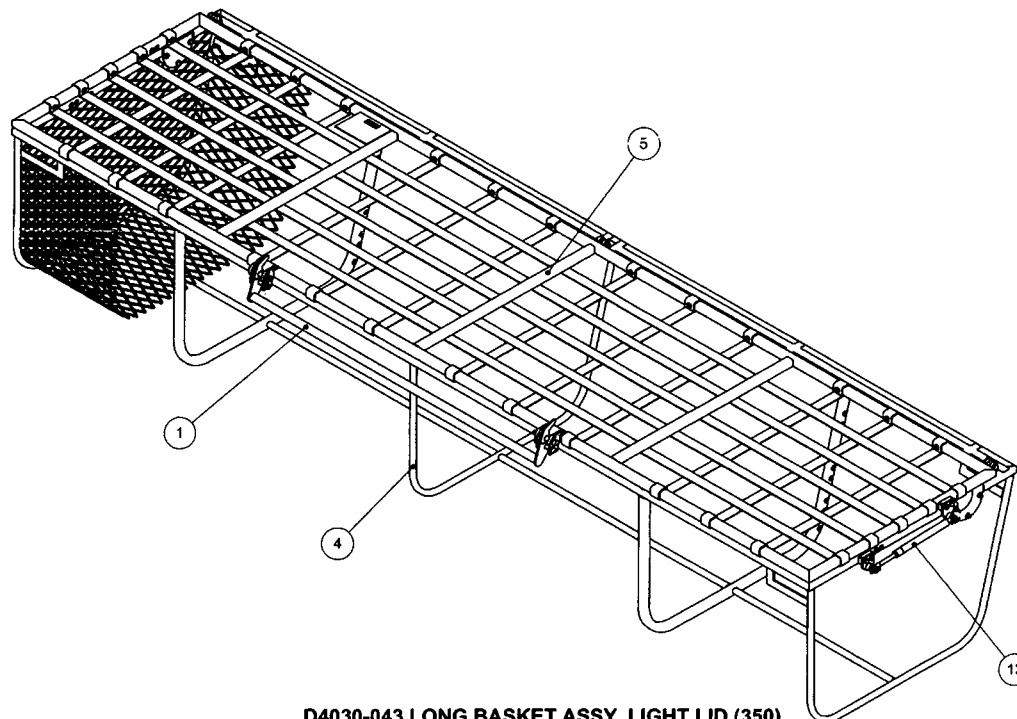
RELEASED
2013-08-16

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

Handwritten: #15-12-01
139692

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

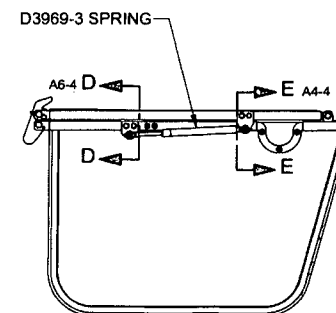
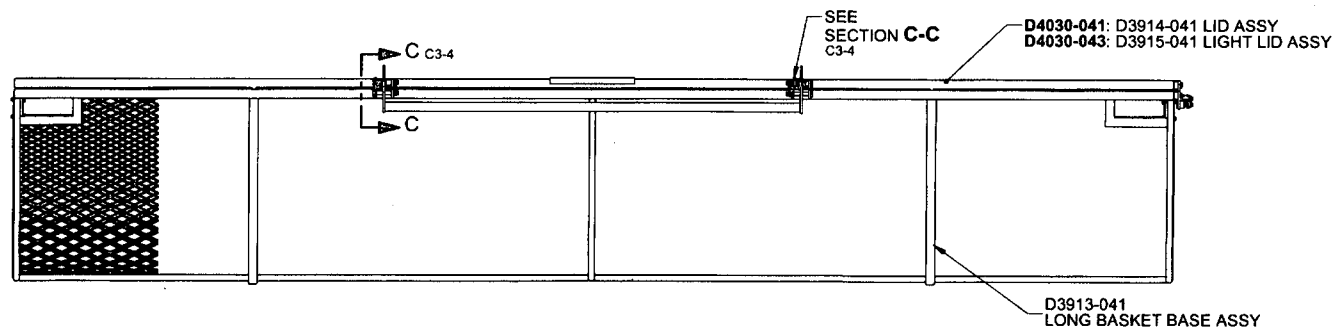
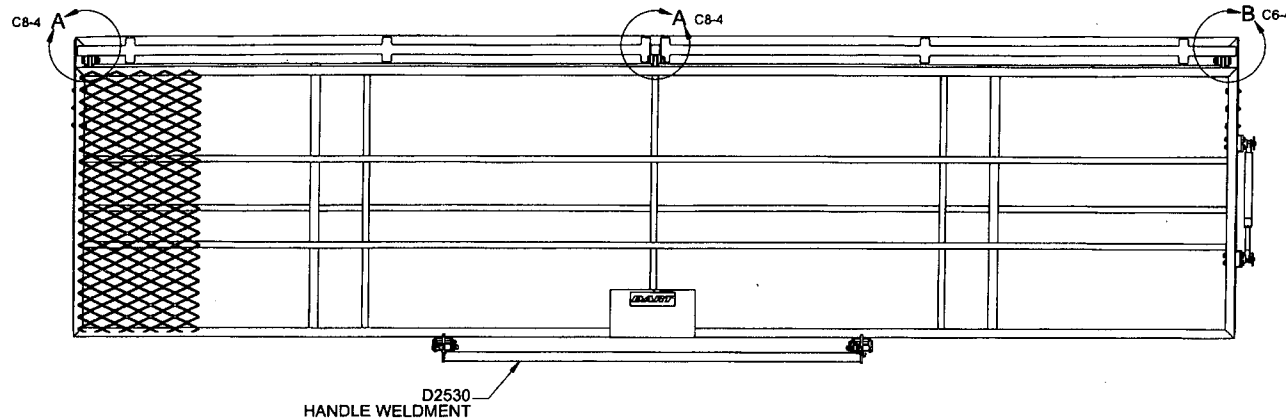
RELEASED
2013-08-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
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RELEASED
2013-08-16



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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8

7

6

5

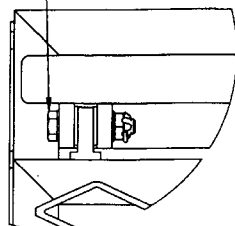
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3

2

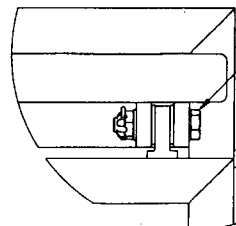
1

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



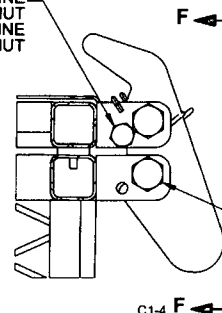
DETAIL A D8-3
D5-3

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-3

D4030-041: AN3-16A BOLT, MACHINE
MS21042L3 NUT
D4030-043: AN3-20A BOLT, MACHINE
MS21042L3 NUT

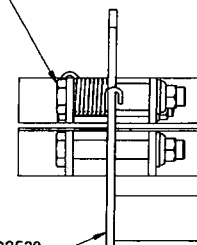


SECTION C-C B4-3
B6-3

D4030-041: AN5-17A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT, MACHINE
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-4

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-3

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-3

RELEASED
2013-08-16
M

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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